

## DUCT WITH WIRE LOCATOR

### RELATED APPLICATIONS

This application claims subject matter disclosed in U.S. provisional  
5 application Serial No. 60/416,352 filed October 4, 2002, the benefit of the filing date  
of which is hereby claimed.

### BACKGROUND OF THE INVENTION

This application relates to the art of plastic duct and, more particularly, to such  
duct having a longitudinally extending wire embedded in the wall thereof. The  
10 invention is particularly applicable to toneable duct and will be described with  
specific reference thereto. However, it will be appreciated that the invention has  
broader aspects and is applicable to other types of duct having items embedded in the  
wall thereof.

Toneable duct is plastic duct that has an electrically conductive longitudinally  
15 extending wire embedded in the wall thereof. A long string of buried pipe can be  
located by passing a signal through the wire and using instruments at the surface to  
locate the pipe by detecting the signal.

The wire is very small and difficult to locate by looking for the exposed wire  
end at an end of a duct. The wire must be exposed to join adjacent pipe sections and  
20 this requires cutting into the exterior surface of the pipe at the end portion thereof  
with a utility knife or other tool. The plastic is very hard and difficult to cut, and the  
process of cutting into the pipe for exposing the wire sometimes results in breakage of  
the wire.

It would be desirable to have an improved way of visually identifying the  
25 location of the wire. It also would be desirable to have an improved way of exposing  
the wire along the end portion of the pipe once it is located.

## SUMMARY OF THE INVENTION

A toneable duct of the type described is made by coextruding the duct, the wire and a longitudinally extending stripe that overlies the wire.

5 The plastic stripe has a distinct visual appearance compared to the plastic pipe to provide easy visual identification of the wire location. In one arrangement, the stripe is of a different color than the duct.

10 The stripe plastic material also is softer than the duct plastic material so that it is easier to cut into or cut-away the stripe material for exposing the wire along the exterior surface thereof at an end portion of the duct. In a preferred arrangement, the stripe plastic material is compatible with the duct plastic material so that the two materials crosslink to make the stripe an integral part of the duct. In one arrangement, the duct may be extruded of high density polyethylene while the stripe is extruded of ~~low~~ density polyethylene having a different color than the high density polyethylene.

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15 For relatively large duct diameters, the stripe provides a longitudinally extending concave recess in the cylindrical exterior surface of a duct. For relatively small diameter duct, the stripe provides a longitudinally extending convex bulge that extends outwardly of the cylindrical exterior surface of a duct.

It is a principal object of the invention to provide an improved toneable duct.

20 It is another object of the invention to provide a toneable duct having an improved arrangement for identifying the location of a wire that is embedded in the duct wall.

It is a further object of the invention to provide a toneable duct having an arrangement that makes it easier to expose the wire along the exterior surface thereof at an end portion of the duct.

It is also an object of the invention to provide a toneable duct having a longitudinally extending wire embedded in the wall thereof beneath a stripe of plastic material that is softer than the duct plastic material while being compatible therewith for crosslinking.

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#### BRIEF DESCRIPTION OF THE DRAWING

FIG. 1 is partial cross-sectional elevational view showing a typical arrangement for simultaneously extruding a cylindrical duct of plastic material, a wire embedded in the wall of the duct and a stripe of different plastic material overlying the wire;

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FIG. 2 is a cross-sectional elevational view of duct having a wire embedded in the wall thereof beneath a longitudinal stripe of plastic material;

FIG. 3 is a partial cross-sectional elevational view showing a longitudinal concave depression in the plastic stripe at the exterior cylindrical surface of a duct; and

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FIG. 4 is a partial cross-sectional elevational view showing a longitudinally extending bulge in the plastic stripe that extends outwardly from the cylindrical outer surface of a duct.

#### DESCRIPTION OF A PREFERRED EMBODIMENT

Referring now to the drawing, wherein the showings are for purposes of illustrating a preferred embodiment of the invention only and not for purposes of limiting same, FIG. 1 shows an extrusion apparatus A having a die 1 and a mandrel 2 that form a generally cylindrical passage for flow of plastic material 3 that exits the die lip as a generally cylindrical duct B and enters a vacuum sizer C.

A hollow screw 4 extends through die 1 into the cylindrical passage between the die 1 and mandrel 2. A copper wire 5 is fed from a coil 6 through screw 6 so that

the wire is embedded in the wall of duct B. The degree of penetration of the screw into the cylindrical passage controls the location of the wire within the duct wall.

A coextruder D downstream from screw 4 extrudes a small stripe 7 of different colored plastic material directly over the location of wire 5.

5           The plastic material used for stripe 7 is different from the plastic material used for duct B. The stripe plastic material has a different visual appearance than the duct plastic material for easily identifying the location of the wire in the duct. By way of example, stripe 7 may be of a different color plastic material than the plastic material used for duct B.

10           The plastic material used for stripe 7 also is softer than the plastic material used for duct B. This makes it much easier to cut in to or remove the stripe along the exterior surface of the duct at an end portion thereof to expose the wire for connecting same to another wire on an adjacent duct when two ducts are joined together.

15           The plastic material used for stripe 7 preferably is compatible with or from the same family as the plastic material used for duct B so that the stripe plastic material will crosslink and fuse with the duct plastic material. By way of example, the plastic material used for duct B may be a high density polyethylene while the plastic material used for stripe 7 is a ~~low~~ <sup>or lower</sup> density polyethylene.

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20           FIG. 2 shows cylindrical duct B having cylindrical inner and outer surfaces 12, 14. Wire 5 extends longitudinally of duct B parallel to the duct longitudinal axis and is located closer to outer surface 14 than to inner surface 12. Stripe 7 overlies wire 5 to indicate the location of the wire. Wire 5 may be located at the interface between stripe 7 and duct B or may be encapsulated within the plastic material of stripe 7.

25           By way of example, wire 5 may be 22 gauge copper wire according to the American Wire Gauge size. As an example, a duct having an outside diameter of 1.900 inches has a peripheral wall thickness measured radially of the duct that is

0.173 to 0.194 inch. The stripe of different plastic for such a pipe is around 0.200 inch wide by around 0.050 inch deep.

5 The thickness of the duct wall should be at least 0.14 inch in order to have sufficient stripe plastic material overlying the wire to avoid having a longitudinally extending bulge on the exterior cylindrical surface of the duct. For smaller duct sizes, such as one inch or smaller outside diameter, the duct wall thickness may be around 0.097 inch or smaller. The stripe of different plastic material then will make a convex outward bulge on the cylindrical exterior surface of the duct that may extend around 0.043 outwardly from the duct exterior surface.

10 FIG. 3 shows a relatively large diameter duct B' having longitudinally extending plastic material stripe 7a overlying wire 5 and forming a longitudinally extending concave depression in the external cylindrical surface of the duct.

FIG. 4 shows a smaller diameter duct B" having a longitudinally extending stripe 7b of plastic material overlying wire 5 and forming a longitudinally extending  
15 convex bulge that extends outwardly from the duct outer cylindrical surface.

For some purposes, it is possible to extrude the wire in a longitudinal recess or channel in the exterior surface of the duct. The stripe of plastic material may then be extruded over the wire to fill the longitudinal recess or channel in the exterior surface of the duct downstream from the duct extrusion die. This may be done while the duct  
20 material remains soft or the duct may be reheated along the wire recess so that the stripe plastic will bond to the duct plastic material over the wire.

Although the invention has been shown and described with reference to a representative embodiment, it is obvious that alterations and modifications will occur to others skilled in the art upon the reading and understanding of this application.  
25 Therefore, it is to be understood that the invention may be practiced otherwise than as specifically described herein while remaining within the scope of the claims.